

Work Order ID 68002

Tuesday, April 05, 2011 10:49:13 AM



Page 1

Item ID: D4380-29

Accept



Setup Start



Revision ID: PRELIM

Item Name: Vent, Center Combination

Start Date: 4/5/2011 Start Qty: 1.00



Required Date: 4/5/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

**PRELIMINARY
ISSUE**



Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #
Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4380

PAG PAZ

11/04/06

100



HandThermo

Hand Finishing Thermoforming

Memo

1-Cut Sheet to required Blank

SCRAP

105



HandThermo

Hand Finishing Thermoforming

Dry Material

Memo

Dry Sheet as per QSI022 Kydex

Temp:

150°

Time IN:

6:00 PM 11/04/05

Time OUT:

7:00 AM 11/04/06

1

BB
11/04/06

BB 11/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop



Start Date: 4/5/2011 Start Qty: 1.00
Required Date: 4/5/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

PRELIMINARY ISSUE

Reference:

Approvals: Process Plan: MC Date: 11-04-05 Tooling:

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA124 using tool DT9749

Dwg Rev: PA7Folio Rev: A

1 BB 11/04/06

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

1 BB 11/04/06

130

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

BB
11/04/06

Dart Aerospace Ltd

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Page 3

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Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Trim to finished dimensions as per Dwg

DL
11/04/06

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Complete FAI document

1

BB
11/09/06

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*-inspected 12 parts
Dwg only**8/10/07**(FD)*

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:49:11 AM

Page 1

Work Order ID: 68002



Parent Item: D4380-29



Parent Item Name: Vent, Center Combination

Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue. 11/04/04 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	787.2912	6.9375	6.9375			



6185 KYDEX .080"



Location

Loc Qty

Loc Code

therm

787.2912

116576

787.2912

6.9375

Wk
11/04/06

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 68002
Description: VEST CENTER COMBO	Part Number: 4380-29
Inspection Dwg: 4380-29 Rev: PA7	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB **Date:** 11/04/06

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.0	.100	16.92	✓		TAPE 1H-05	
7.0	.100	7.0	✓		" "	
3.0	.100	6.0	✓		" "	
4.0	.100	4.0	✓		" "	

Measured by: JB **Date:** 11/04/06

Audited by: 8 to Pm 7 Dugan **Date:** 11/04/07

Preliminary Approval: **Date:**

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

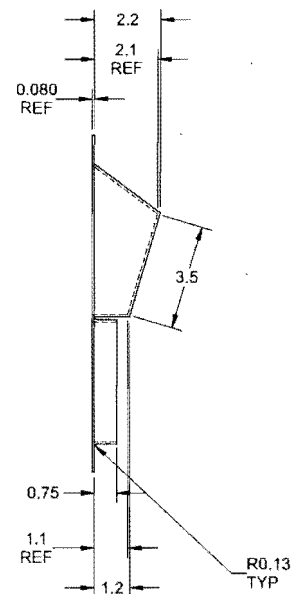
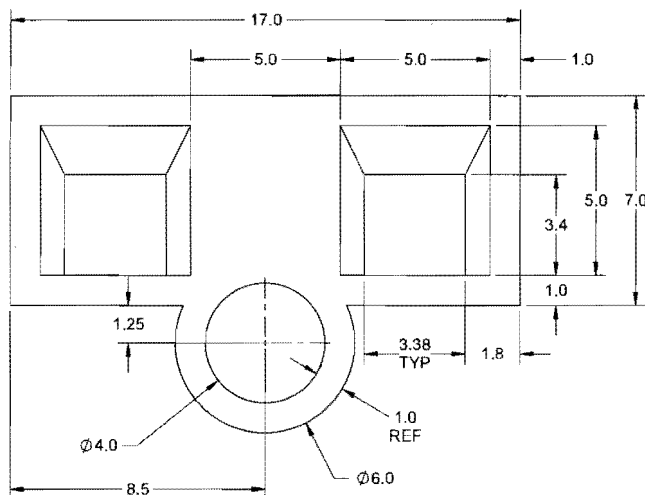
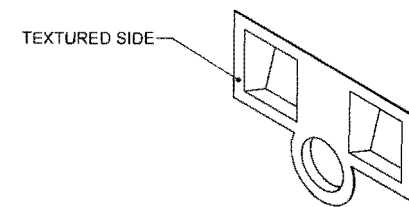
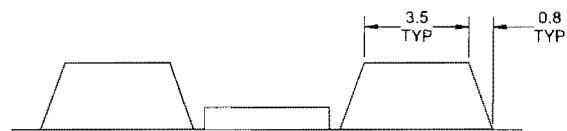
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NOTE: Date & initial all entries



D4380-29 VENT, CENTER COMBINATION

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.52 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM -29 PART PER MOULD DT9749.
TRIM PER MOULD LEAVING FINISHED EDGE.

PRELIMINARY ISSUE

SC 11.04.05

DESIGN	<i>SC</i>	DART AEROSPACE LTD	
DRAWN	<i>SC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA7
MFG. APPR.		D4380	SHEET 15 OF 19
APPROVED		TITLE	SCALE
DE APPR.		CEILING POCKETS	NTS
DATE	11.04.05	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUBJECT TO THE EXPRESS AGREEMENT THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Monday, April 04, 2011 9:16 AM
To: 'Daryl Leger'
Cc: 'JEANLUC MENARD'; Bill Beckett; 'Linda Lacelle'; 'Harvey Siemens'; 'Mike Petsche'
Subject: D4323 & D4380 - Parts can be untrimmed

To Whom It May Concern,

The parts with p/n's D4323-XX and D4380-XX can be shipped to Calgary untrimmed, or even slightly out of spec in order to get parts here asap so they can be installed on the Westpac machine.

Thanks,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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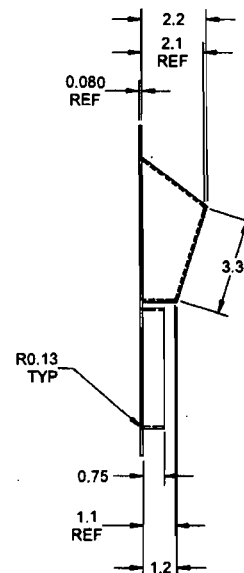
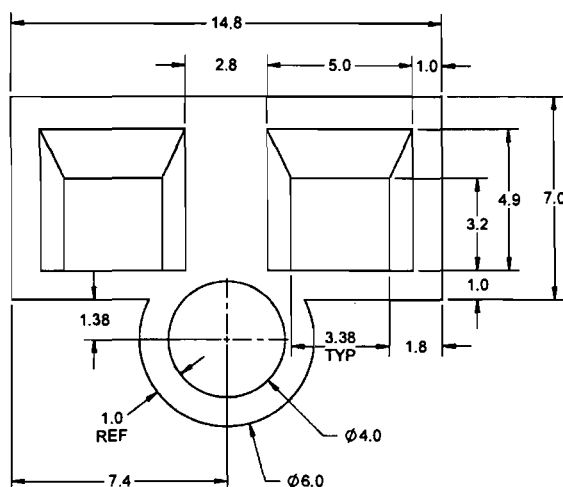
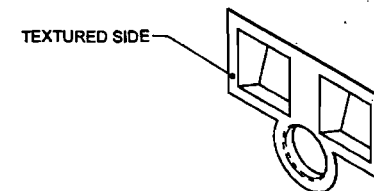
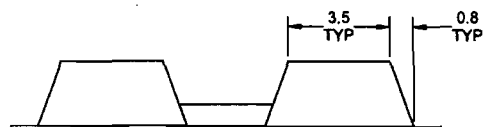
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D4380-29 VENT, CENTER COMBINATION

RELEASED
2011-06-10

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.64 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM PER MOULD DT9749 AND DART QSI 022
- 10) TRIM PER MOULD LEAVING FINISHED EDGE
- 11) MAXIMUM INSIDE RADIUS = 0.188

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DC	D4380	SHEET 15 OF 18
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CEILING POCKETS	NTS
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